












Date: Tuesday, 07/04/2009 10:22:39 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT STEP MOUNTING LUG
Job Number : 46987	
Estimate Number : 11747	
P.O. Number :	Part Number : D34591
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3459 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 46864	Material :
Written By :	Due Date : 30/04/2009 Qty: 10 Um: Each
Checked & Approved By : JUD 09.04.07	
Comment : Est Rev: A New Issue 06-01-06 JLM Est Rev: B Waterjet 06-05-23 ec	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6B0187X04000 6061-T6 Bar .178 x 4.00
	
MAT NOT PULLED USED .188 SHEET	
Comment: Qty.: 0.3644 f(s)/Unit Total: 3.6435 f(s) 4.00" X .188" BAR 6061-T6 (M6061T6B4.000X.188) Batch: 110993 AB 9-4-13	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3459 Dwg Rev: A AB 9-4-13 Prog Rev: A 2-Deburr if necessary AB 9-4-13 m- 09/04/14	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
AB 9-4-13	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK 5 09/04/14 X15	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PAT 9/4/14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 46987

Part Number: D34591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk
09-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46987
Description: Float Step Mounting Plate		Part Number: D3459-1
Inspection Dwg: D3459	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

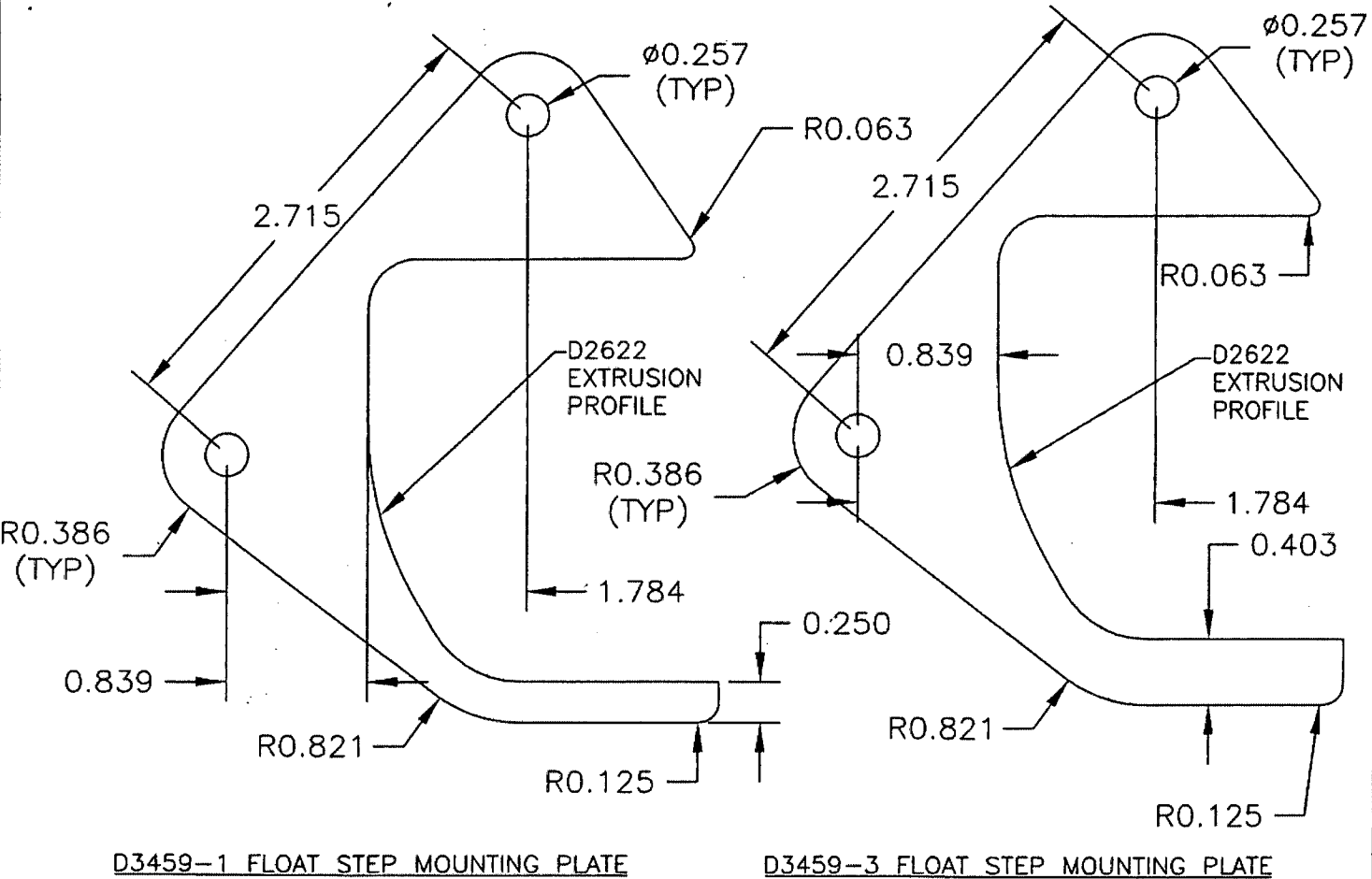
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.259	X			
2.715	+/-0.010	2.718	X			
0.250	+/-0.010	.259	X			
R0.125	+/-0.010	.125	X			
R0.063	+/-0.010	.063	X			
0.839	+/-0.010	.839	X			
0.188	+/-0.010	.186	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-4-13	Date: 09/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.26	New Issue	KJ/EC/DD	[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3459	SHEET 1 OF 1
DATE	TITLE		SCALE
05.09.23	FLOAT STEP MOUNTING PLATE		1:1
A	05.09.23	NEW ISSUE	



05.11.14

D3459-1/-3 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITH NO. 4) PRICE

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